

# Work Order ID 115540

April-03-14 1:06:00 PM

**\*115540\***

Page 1

Item ID: D4541-1

Revision ID:

Item Name: Bracket

Start Date: 4/03/14

Required Date: 4/08/14

Reference:

Start Qty: 6.00

Req'd Qty: 6.00

**\*6\***

**\*6\***

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4541

E

0.00

0.00

0.00

0.00

100

**\*100\***

Waterjet

FLOW CNC Waterjet

Memo

1- Cut as per dwg

Prog rev: EQ

Dwg rev: E

2- Deburr

QC2- Inspect parts off machine FAI/FAIB

110

**\*110\***

QC

Quality Control

Memo

6

EQ

14-4-3

6

EQ

14-4-3

# Work Order ID 115540

April-03-14 1:06:00 PM

**\*115540\***

Page 2

Item ID: D4541-1

Revision ID:

Item Name: Bracket

Start Date: 4/03/14 Start Qty: 6.00 **\*6\***

Required Date: 4/08/14 Req'd Qty: 6.00 **\*6\***

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**DAS**  
27  
9-89  
14/4/4

**\*120\***

QC

Memo

Quality Control

130

**Memo**  
BEND INDIVIDUAL TABS AS PER DWG

0.00

**\*130\***

Small Fab

Small Fab

0.00

**DAS**  
30  
9-89

140

QC5- Inspect part completeness to step on W/O

0.00

**DAS**  
27  
9-89  
14/4/11

**\*140\***

QC

Memo

Quality Control

14/04/10

**Work Order ID 115540**

April-03-14 1:06:00 PM

**\*115540\***

Page 3

Item ID: D4541-1

Revision ID:

Item Name: Bracket

Start Date: 4/03/14

Start Qty: 6.00

**\*6\***

Required Date: 4/08/14

Req'd Qty: 6.00

**\*6\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

144

Chemical Conversion Coat per QSI005 4.1

0.00

**\*144\***

HandFinish

Memo

0.00

Hand Finishing

147

QC7-Inspect Chemical Conversion Coat

0.00

**\*147\***

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 5T531

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

DAS  
27  
9/59

14/4/11

6

7/9/14 4/11

6

6x

DAS  
28  
9-89

APR 11 2014



**Work Order ID 115540**

April-03-14 1:06:00 PM

**\*115540\***

Page 4

Item ID: D4541-1

Revision ID:

Item Name: Bracket

Start Date: 4/03/14

Start Qty: 6.00

**\*6\***

Required Date: 4/08/14

Req'd Qty: 6.00

**\*6\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center ID

160

**\*160\***

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

MLJ 14-04-14

① 14-04-11

# Picklist Print

April-03-14 1:05:59 PM

Page 1

Work Order ID: 115540

**\*115540\***

Parent Item: D4541-1

**\*D4541-1\***

Parent Item Name: Bracket

Start Date: 4/03/14

Required Date: 4/08/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B  
12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as  
per dwg revC DD verf:EC IPP REV:D 13.04.23 as per dwg  
revD DD verf:JLM IPP REV:E 14.03.24 as per dwg revPE2 DD  
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased		No				100	sf	313.3832	0.416	3	

**\*M6061T6S 0.32\***

6061-T6 Sheet 0.032"

**\*\***

EL 14-4-3

Location

Loc Qty

Loc Code

MAT021

313.38317

123483

8.57

m125822

17

m127272

119.43317

m128054

168.38

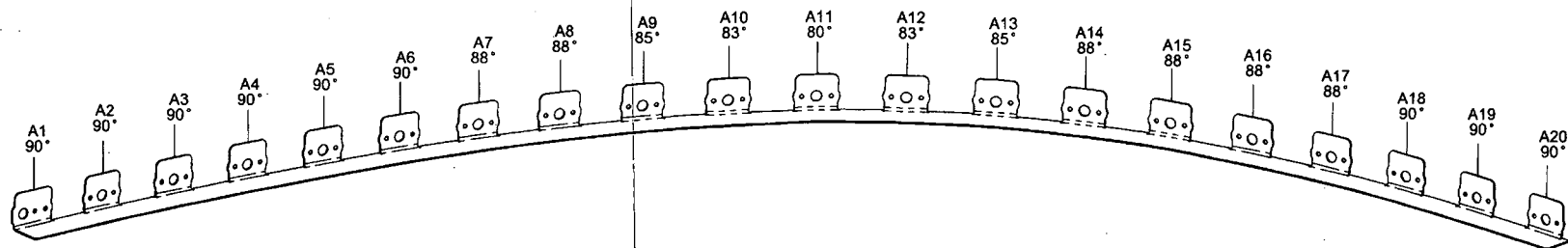
8.66



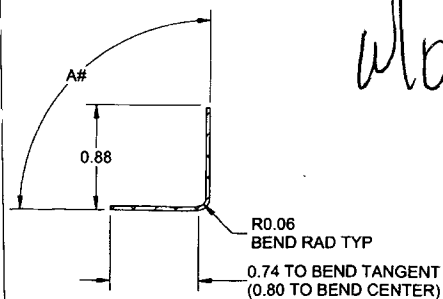




8 7 6 5 4 3 2 1



# D4541-1 BRACKET



WLB 115840

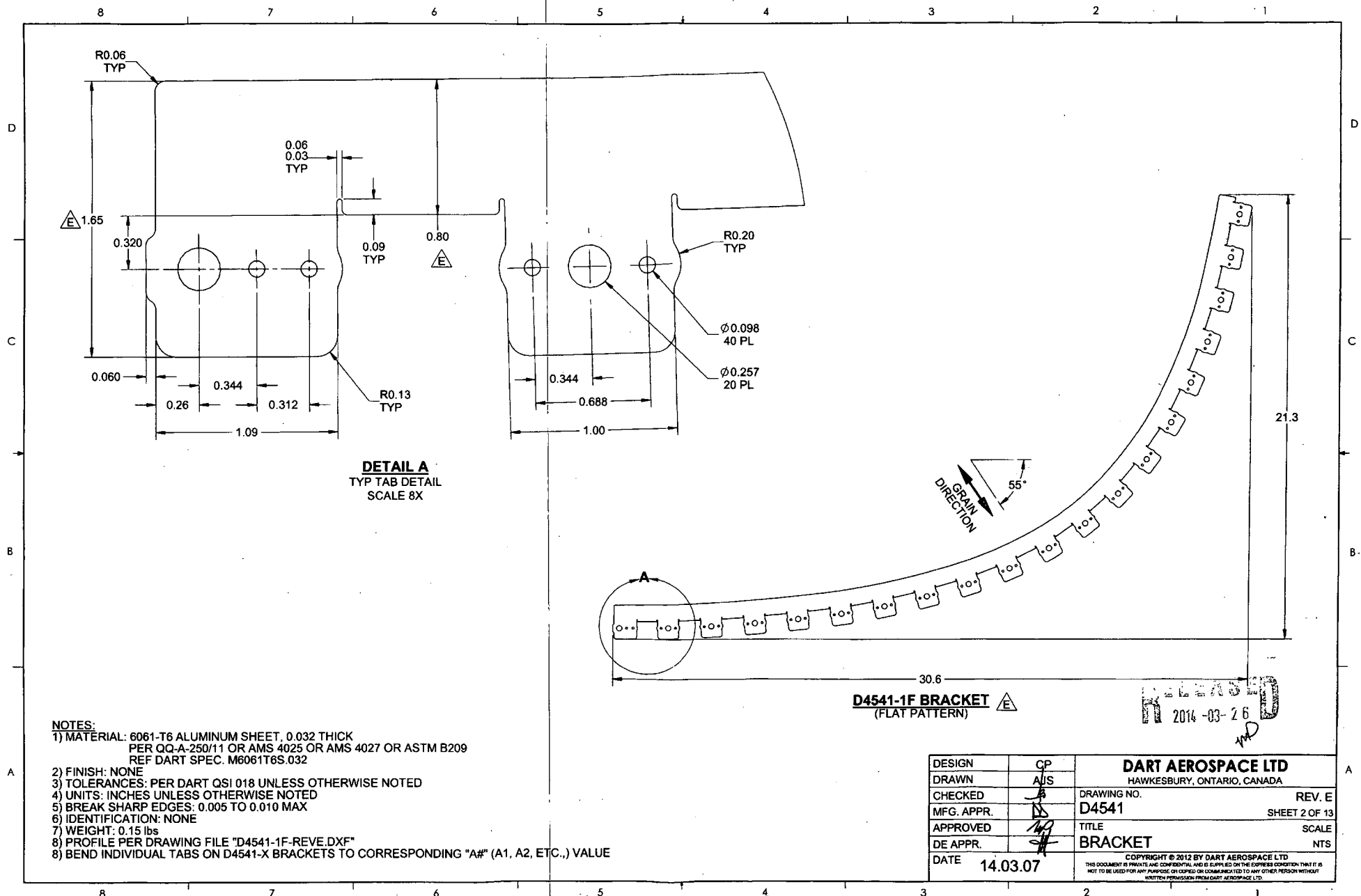
RELEASED  
2014-03-26

## NOTES:

- 1) MATERIAL: MAKE FROM D4541-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.) VALUE

E	ADDED -1 & -2 BENT. SHT 2 & 4 ZN C8 0.80 DIM WAS 0.60. SHT 10 ZN C7 & C4 1.75 DIM WAS 1.55 -5 & -6 UPDATED ACCORDINGLY. SHT 13 ZN C8 2.5 DIM WAS 2.3, 1.66 DIM WAS 1.46. -7 & -8 UPDATED ACCORDINGLY.	AJS	14.03.07
D	ADD BENT SHAPES -3/-4/-7/-8	CP	13.02.04
C	D4541-5F WAS -5; ADD -5/-6; RMV FINISH (-1/-2/-3/-5/-7); 0.70 WAS 0.60 (ZN D1-3)	CP	12.04.20
B	-5: 1.55 WAS 1.45 (ZN C4-4)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4541</b> TITLE <b>BRACKET</b> SCALE <b>NTS</b> <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.03.07		

8 7 6 5 4 3 2 1



# NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs
- 8) PROFILE PER DRAWING FILE "D4541-1F-REVE.DXF"
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC..) VALUE